Friday, 2/23/2007 8:31:26 AM Kim Johnston **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : WEARPLATE Customer Job Number : 10299 **Estimate Number** · NIA : D25775 P.O. Number Part Number S.O. No. : NIA : 2/23/2007 D2577 REV E **Drawing Number** This Issue : NC : N/A Prsht Rev. Project Number : *UliA* : 30812 : SMALL /MED FAB First Issue **Drawing Revision** : NA Material Previous Run 20 Um: : 3/24/2007 Each Due Date Written By Checked & Approved By Comment : Est: Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM **Additional Product** Job Number: Description: Seq. #: 1010/1025/A21/6aA SHEET 1.0 M1010S16GA Comment: Qty.: 1.0301 sf(s)/Unit Total: 20.6010 sf(s) 1010/1025 16GA SHEET (m1010s16ga) Batch: 103788 WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2577 ml 07 03 16 Dwg Rev: Prog Rev:__ 2-Deburr if necessary 120160 3.0 QC2 Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-5T1 SECOND CHECK 4.0 QC8 MS Comment: SECOND CHECK 20 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #: Fault Category:	NCR: Yes	(No) DQA		Date: <u>(</u>	1 <u>1</u> 12/03/06		

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annroyal				
DATE	STEP	Section A	Initial Chief Eng		gn & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:26 AM User: Kim Johnston **Process Sheet** Drawing Name: WEARPLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 30879 Part Number: D25775 Job Number: Description: Seq. #: **Machine Or Operation:** BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE 1-Form on brake using DT8155 and DT8179 as per Dwg D2577 2-Form joggle using DT8157 as per Dwg D2577 3-Identify as D2577-5 07/03/24 70 INSPECT WORK TO CURRENT STEP 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 8.0 POWDER COATING M 101 601 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock 3/26 Location: FP FINAL INSPECTION/W/O RELEASE 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE U Spish. The Job Completion

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W/O:		WORK ORDER CHANGES							
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Part No:	PAR #:	Fault Category:	NCR: Yes N	lo DQA:	Date: _	.
			QA: N/	C Closed:	Date: _	
NCR:		WORK ORDER NON-CON	FORMANCE (NCR))		
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		Description of NC	Corrective Action Section B			\/ifi4i	Ammerical	Ammaral
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	- Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30879
Description: Wearshoe	Part Number:	D2577-5
Inspection Dwg: D2577 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

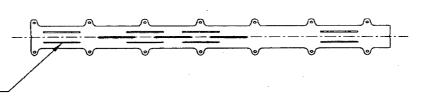
X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.50	J		Hight Gur	
3.182	+/-0.010	3.184	j		VECN	5
43.50	+/-0.030	43.50	1		Mensorins	troe
38.500	+/-0.010	38.500	1		MOASUring	
2.50	+/-0.030	2.486	/		Hight Gun	ne
2.43	+/-0.030	2.437	V		VerN	0
R0.129	+/-0.010	RO.129			Radius Gu	Ace
0.220	+/-0.010	0.220	J		YLYN	0
0.300	+/-0.010	0.302	1		Vern	
0.375	+/-0.010	0.376	V		Hight Guns	e.
0.063	+/-0.010	0.058	√		Vern	<u> </u>
Also inspected b	y template	D2577-5	TI			

Measured by: M M	Audited by:	Prototype Approval:	N/A
Date: 07.03.6 16	Date: 07/03/24	Date:	N/A

Rev	Date	Change	Revised by	Approved_
A	06.12.07	New Issue	KJ/JLM	B
<u> </u>			• • •	

7560 HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH (TYP. 11 PLS.) WELD AFTER BENDING AS ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





SHOP COPY SHOP COPY SHOP COPY SUBJECT TO AMEXING WITHOUT NOTICE (8 PLACES) A 1.50 (TYP)	SECTION A-A SCALE 1:5 R2.00 D2941-300 (REF) REMOVE POWDER
0.12 (TYP)	0.10 COAT FROM THESE

D2577-21 & D2577-23 WEARSHOE MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
СНЕСКЕЙ	APPROVED	DRAWING NO. REV. E
+	ŧ	D2577 SHEET 1 OF 5
DATE		TITLE SCALE
00.09.22		WEARSHOE 1:10
 Α	96.09.16	NEW ISSUE
 В	96.12.04	ADD HARDCOAT WELDS
 С	97.05.30	CHANGE HOLES TO OBROUNDS
 D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
 [II]	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

00.09.22 DRAWING N WEARSHOE

SHEET

2 OF

R0.128 2.50 -(REF) (2 PLACES) SEE DETAIL B ON PAGE 5 2.43 --- 6.000 3.182 18.000 24.000 30.000 36.000

D2577-101 FLAT PATTERN

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BREAK ALL SHARP CORNERS 0.010 TO 0.020

AISI 1010-1025 OR ASTM A36/A366/A569/A570 MATERIAL:

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

8.50 — ON FLAT	R50.0
SHOP COPY RETURN TO RETURN TO ENGINEERING ENGINEERING ENGINEERING SUBJECT TO AMENDMEN SUBJECT TO AMENDMEN SUBJECT TO AMENDMEN NO. 300	SEE DETAIL C ON PAGE 5 FOR D2577-11 ONLY D

& D2577-13 LONGITUDINAL BEND MAKE FROM D2577-101

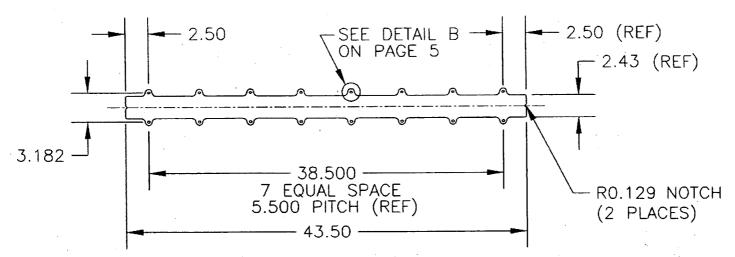
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

00.09.22 DRAWING N WEARSHOE

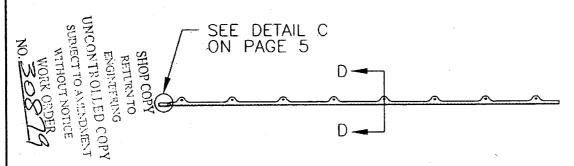
SHEET 3 OF 5

SCALE

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

SHARP CORNERS 0.010 TO 0.020 BREAK ALL

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 FINISH: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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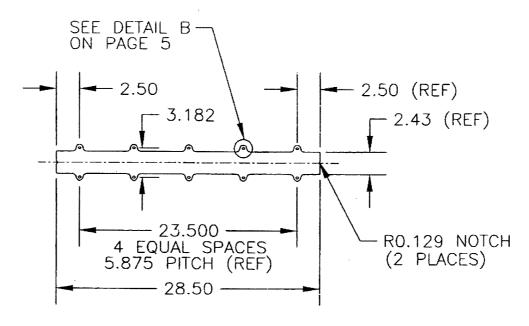
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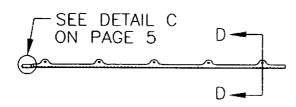
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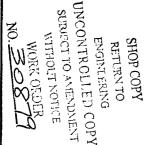
WEARSHOE

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND





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BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 FINISH: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

LD2577-7 WEARSHOE

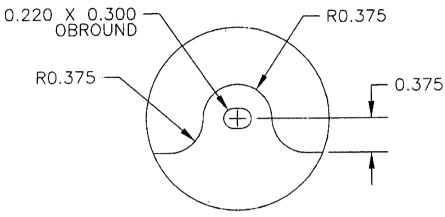




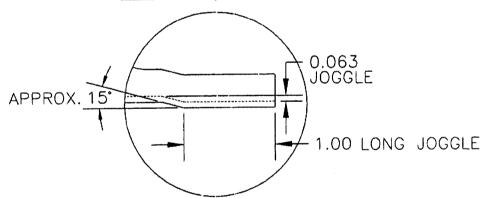
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CHECKED	APPROVED	DRAWING NO.	REV. E
DATE	1 #	D2577	SHEET 5 OF 5
00.09.22		WEARSHOE	1:10

DETAIL B (SCALE 1:1)

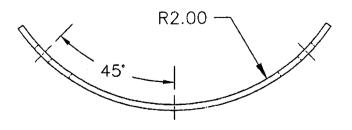




DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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